

AMENDED CLAIM SET:

1. – 5. (cancelled).

6. (withdrawn) In a carbon fiber brake perform comprising an annular disc built up of a plurality of annular fabric arc segments composed of unidirectional continuous fibers and staple fibers, wherein each of said annular segments has radial directions oriented from the center of the annulus to points on its outer diameter and wherein the radial direction that passes through the center of the segment outer diameter constitutes a segment arc bisector, the improvement which comprises arranging said fabric segments with the continuous fibers in said fabric segments oriented in the radial direction and parallel to the segment arc bisectors.

7. (withdrawn) A shaped fibrous fabric structure having an annular disc configuration and being formed of multiple, successively-stacked layers of abutting fabric arc segments composed of continuous fibers and staple fibers, said fabric arc segment layers being interconnected by at least a portion of said staple fibers, wherein each of said annular segments has radial directions oriented from the center of the annulus to points on its outer diameter and wherein the radial direction that passes through the center of the segment outer diameter constitutes a segment arc bisector, and wherein the continuous fibers in said fabric segments are oriented in the radial direction and parallel to the segment arc bisectors.

8. (withdrawn) The fabric structure of claim 7, wherein the continuous fibers and the staple fibers consist essentially of oxidized polyacrylonitrile (OPAN) fibers.

9. (currently amended) A method for making an annular perform composite, which method comprises the steps of sequentially:

a.) providing a needle-punched nonwoven fabric comprising a major portion of unidirectional continuous fiber tow and a minor portion of staple fiber web,

b.) making from said fabric a plurality of segments having the continuous fibers oriented in said fabric segments in the radial direction and parallel to segment arc bisectors of said fabric segments,

c.) arranging said segments annularly and needling said segments together to provide a multilayered intermediate having a weight and dimension calculated to provide a desired perform density for the application,

d.) heating said multilayered intermediate to a temperature above 1500°C in an inert atmosphere to convert the fibers to carbon, and subsequently

e.) densifying the carbonized product by carbon deposition *in situ* cracking of a carbon-bearing gas [[of]] or by impregnation with liquid pitch or carbon-bearing resin followed by charring of the resin to achieve the desired perform density.

10. (cancelled).

11. (previously presented) The method of claim 9, in which the needle-punched nonwoven fabric provided in step a.) is a carded needled punched staple web which has been needled to a layer of needle-punched continuous tow.

12. (previously presented) The method of claim 9, in which carbonized performs produced by step d.) are densified with a mixed hydrocarbon gas using a forced flow CVI/CVD process to deposit carbon matrices in fibrous perform substrates.

13. (withdrawn) A carbon fiber brake perform, produced by the method of claim 9.

14. (withdrawn) The carbon fiber brake perform of claim 13, wherein continuous fibers and staple fibers in the needle-punched nonwoven fabric consist essentially of oxidized polyacrylonitrile (OPAN) fibers.